

54679 0 Rev

Work Order ID 53907



Page 1

November 23, 2009 2:40:14 PM

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 23/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: B/Date: 11-23

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

1 - AWM 9-12-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

1 - - *AWM 9-12-07*

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

(1) *BE 09/12/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

0.00

Skidtubes

Memo

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

m112860 BE 09/12/08

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

m112860 BE 09/12/08

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aff cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Towing using DT8091, open to .640" and Deburr

9-12-9

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QS1004- ground welds

0.00

⇒ 8/12/10



QC

Memo

0.00

(40)

φ

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8/12/10



QC

Memo

0.00

(40)

φ

Quality Control

170

Pressure Wash per QS1005 4.3

0.00

⇒ 8/12/10



HandFinish

Memo

0.00

(40)

φ

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date:	23/11/2009	Start Qty:	1.00			
Required Date:	02/12/2009	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 11/2/148</i> Memo START TIME: <i>9:20</i> OVEN TEMPERATURE: <i>325°</i> FINISH TIME: <i>9:50</i>	0.00 0.00				<i>0</i>			
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>XL</i>	<i>0</i>		

BR 09-12-10

= 7 M 09/12/10

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Required Date: 02/12/2009 Required Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

=> M 09/12/11

(X1) 0

Hand Finishing

- 1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112345
Sikaflex expire date: 10/10/08
- 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580
- 3-Inspect for foreign object per QSI 024
- 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112345
Sikaflex expire date: 10/10/08
- 5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M112263

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2 S or b r l u



Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

PP 51229

9/12/14 SP

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

09/12/17

BT 09-12-14
①

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 53907



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2580-1RevD

Manufactured

No

110

Each

1.0000

1.0000



205 Skidtube bent detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

53233

1

140

Each

160.0000

1.0000

D2576-3RevG

Manufactured

No



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

160

43504

12

46661

101

52215

47

1354120 AWM
9-12-03

BE 09/12/03

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	193.0000	20.0000			
Crossbolt Spacer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

71

51525

71

Main Warehouse

ST

122

43988

4

46434

4

46956

2

47797

9

48272

2

51314

71

51315

30

D2855RevA

Manufactured No

200

Each

92.0000

1.0000



Cap



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

92

50513

1

50770

3

51539

88

B 53780 *20 BE 09/12/08

AT M 09/12/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 02/12/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A 		Purchased	No			200	Each	2,171.000	2.0000			
Bolt												

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

100188

2171

105057

188

1983

x2 41 09/12/10

AN960JD10L

Purchased

No

200

Each

5,592.000 2.0000

Washer

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

101291

5592

104885

16

105793

153

109632

236

110985

348

4839

x2 41 09/12/10

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			200	Each	2,880.000	50.0000			
Insert												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2880	
105855	16	
108606	52	
111529	1488	
111779	313	
112772	11	
113238	1000	

AN3C4A

Purchased

No

200

Each

2,075.000 50.0000

BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2075	
112314	13	
112720	12	
112724	3	
112829	88	
112991	39	
113121	920	
113226	1000	

11133359

x50 24 09/12/10

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Shop Packet Print

Page 4

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Comments:

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AN960C10L washer		Purchased	No			200	Each	2,604.000	50.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	2504	
112116	548	
112612	956	
12933	1000	

D3566-13RevC

Manufactured No



Gasket

200 Each 106.0000 1.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	104	
51606	21	
53461	83	
Main Warehouse		
ST	2	
45717	1	
50265	1	

X50 Jul 09/12/10

X1 Jul 09/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3566-5RevC		Manufactured	No			200	Each	48.0000	1.0000			

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

~~353805~~

x1 M 09/11/10

FP

28

51929

2

53804

26

Main Warehouse

FP19

16

52909

16

Main Warehouse

ST

4

36113

1

46186

1

47318

1

51260

1

November 23, 2009 2:40:22 PM

Shop Packet Print

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D3566-1RevC		Manufactured	No			200	Each	65.0000	2.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	36	
52512	3	
53790	33	
Main Warehouse		
ST	29	
46349	1	
51218	1	
51259	3	
53455	24	

x22410a12110

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

November 23, 2009 2:40:22 PM

Work Order ID: 53907



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-11RevD		Manufactured	No			200	Each	33.0000	1.0000			
--------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

1353808

x1 all 09/12/10

FP

5

51905

5

Main Warehouse

FP19

26

51594

3

52125

23

Main Warehouse

ST

2

45823

1

50112

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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D3564-13RevD		Manufactured	No			200	Each	46.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP17	34	
51611	32	
52059	2	
Main Warehouse		
ST	12	
45409	2	
46495	10	

x1 24 09/12/10

D3564-9RevD

Manufactured No

200

Each

21.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP19	19	
51675	1	
52593	18	
Main Warehouse		
ST	2	
44659	1	
45825	1	

13 53806

x1 24 09/12/10

November 23, 2009 2:40:22 PM

Shop Packet Print

Page 9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

November 23, 2009 2:40:22 PM

Work Order ID: 53907



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD		Manufactured	No			200	Each	24.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE	353805	
FG	2	
34806	2	
Main Warehouse		
FP19	7	
51925	7	
Main Warehouse		
ST	15	
45824	1	
47433	1	
52595	13	

x14 09/12/10

D2594-3RevC

Manufactured No

200

Each

840.0000

16.0000



O-Ring, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	27	
51613	27	
Main Warehouse		
ST	813	
52562	813	

x16 09/12/10

November 23, 2009 2:40:22 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2594-1RevC Manufactured No 200 Each 431.0000 16.0000



Plug, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	431	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	309	

x16 H 09/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP ONLY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHIN 1 YEAR
WORK ORDER
NO. 53907
07-11-23

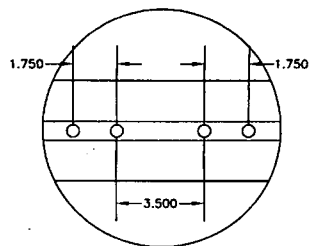
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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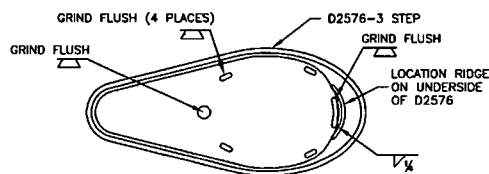
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DETAIL A
SCALE 5:24

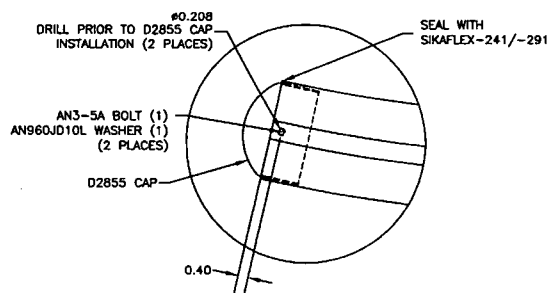


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07-06-28

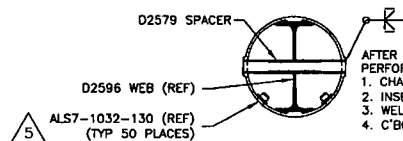
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24

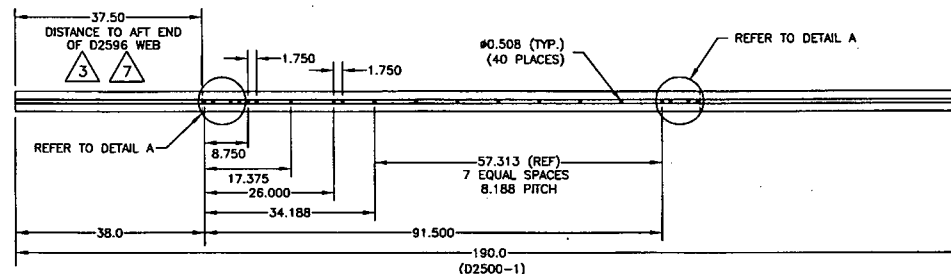


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

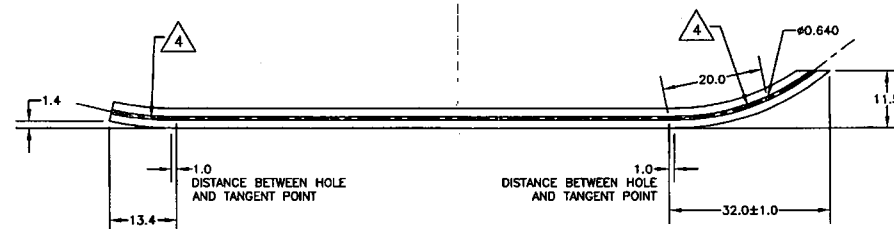
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

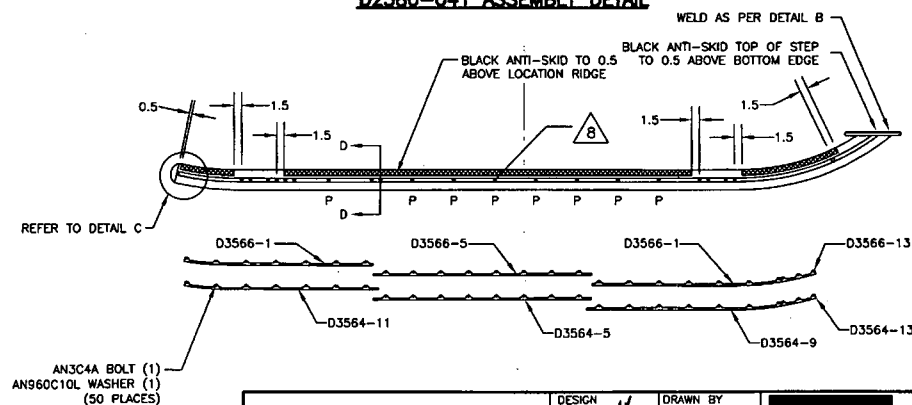
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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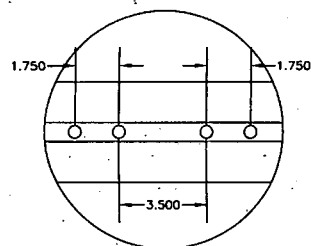
DESIGN	<i>[Signature]</i>
CHECKED	<i>[Signature]</i>
DATE	07.02.27

DRAWN BY	<i>PH</i>
APPROVED	<i>H</i>

DART DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

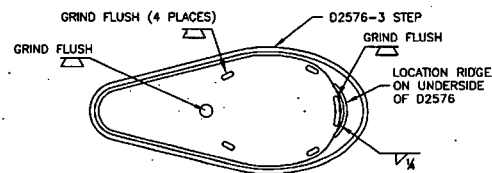
DRAWING NO.	REV. 0
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

DETAIL E
SCALE 5:24

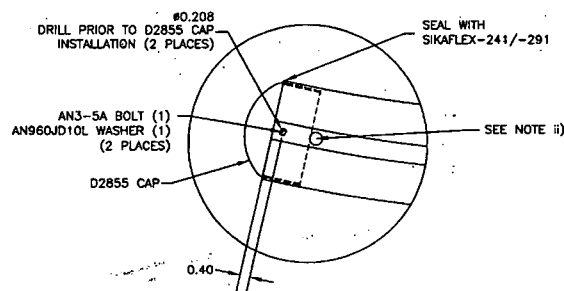


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07-06-28

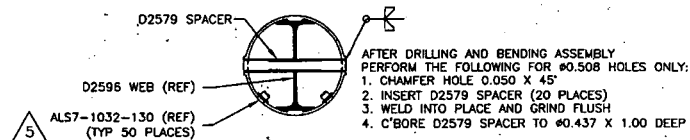
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



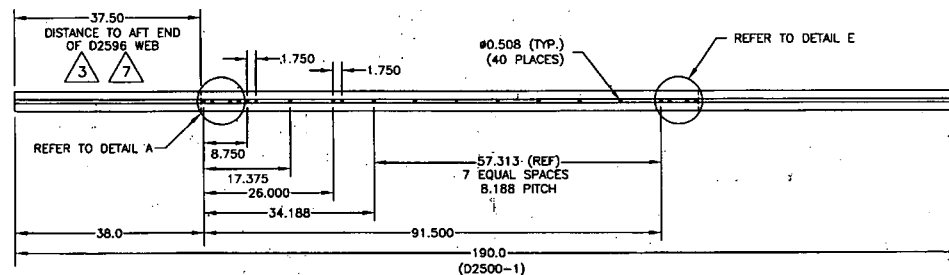
SECTION H-H
SCALE 5:24



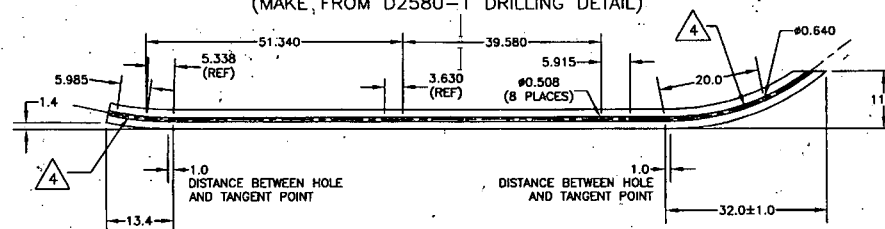
D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

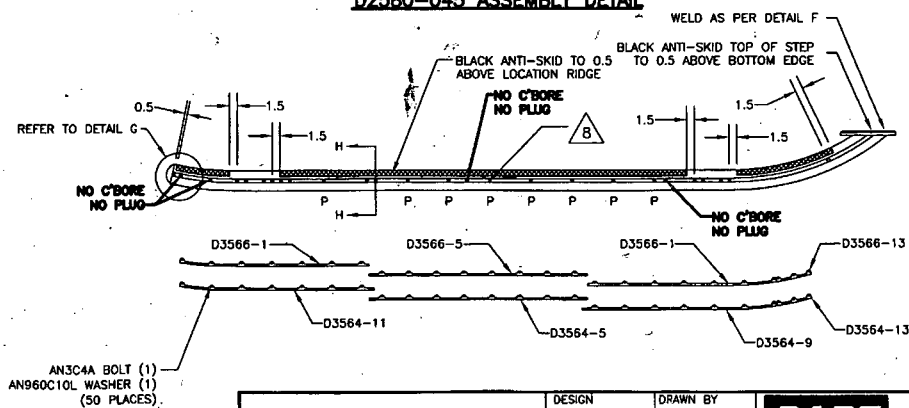
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN

DRAWN BY

PART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

CHECKED *W*

APPROVED,

	DRAWING NO.

REV. D

DATE _____

TITLE

SCALE

205 SKIDTUBE ASSEMBLY

1:24

07.02.27

205 SKIDTUBE ASSEMBLY

1:24

NO. 219

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 53910
Part number: D205-634-041
Description: 205 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Det. Dwl Date of Test Coupon 09-12-04

Welder Barclay Elliott Date of Test Coupon 09-12-04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld